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D4855-1

Job Sheet 183232



42k

Part No: D4855-1

Job Qty: 20 ea

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-3		mL 18/10/03
100	Bandsaw	20 pcs	10/5/18	10/5/18	0.00	0.56	Bandsaw1		mL 18-10-03
110	CNC Vertical Machining	20 pcs	10/5/18	10/5/18	0.29	17.54	HAAS1-5		mL 18-10-03
130	QC	20 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		mL 18/10/09
140	HandFinish	20 pcs	10/5/18	10/5/18	0.00	0.81	HandFinish1		DR 18/10/09
150	QC	20 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		BL 18-10-09
160	Powdercoat	20 pcs	10/5/18	10/5/18	0.00	0.39	Powdercoat1		BL 18-10-09
170	QC	20 pcs	10/5/18	10/5/18	0.00	0.00	QC3		OCT 09 2018 68
180	Packaging	20 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2	5026	OCT 10 2018 9-89
190	QC21-SA	20 Ea	10/5/18	10/5/18	0.00	0.00	QC21		OCT 10 2018 21

Part Op 100 - CUT BLANK AT 3.000"
Descriptions: 110 - 1-Machine per folio FB200
160 - START TIME: 3.70 O.T. 320 FINISH: 3.50. M 83983. OCT 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500	6061-T6 Aluminubar 4.500" X 4.500"	5 ft (.25 ea)	90-Start up Operation	5036064 5080901

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B4.500X4.500	5	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches $\pm$ 0.010	0.885 0.865		878
2	Antenna Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	205
3	Antenna Bracket	0.970Inches $\pm$ 0.030	1.000 0.940		0.97
4	Antenna Bracket	0.970Inches $\pm$ 0.030	1.000 0.940		0.97

5	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.875
6	Antenna Bracket	3.750Inches ± 0.030	3.780 3.720	3.753
7	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius .250
8	Antenna Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter .260
9	Antenna Bracket	2.130Inches ± 0.030	2.160 2.100	2.127
10	Antenna Bracket	1.400Inches ± 0.030	1.430 1.370	1.400
11	Antenna Bracket	1.260Inches ± 0.030	1.290 1.230	1.261
12	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.885
13	Antenna Bracket	0.280Inches + 0.006 - 0.001	0.286 0.279	Diameter 0.285
14	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius
15	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius .380
16	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius .250
17	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240	.250
18	Antenna Bracket	2.500Inches ± 0.030	2.530 2.470	2.498
19	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240	.250
20	Antenna Bracket	4.250Inches ± 0.030	4.280 4.220	4.249
21	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius .250

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval							
Description Work Order Deviation		Disposition		Completed By							
				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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